QC

Quality Control

13-07-22

July-16-13 11:36:56 AM Item ID: D3265-041 Accept \*N900040100\* Setup Start **Revision ID:** Item Name: Basket Base Assembly **Start Date:** 6/14/13 Start Oty: 1.00 \*1\* **Cust Item ID:** Required Date: 6/28/13 Req'd Qty: 1.00 **Customer:** Reference: Run Date: 1307-16 Tooling: MIS Approvals: **Process Plan:** Date: Stop QC: Date: SPC (Y/N): Date: Sequence ID/ Operation Set Up/ Tool ID Tool # Plan Reject Accept Reject Insp. Work Center ID Description **Run Hours** Code Qty Number Qty Stamp Draw Nbr **Revision Nbr** D3265 E 100 Weld per dwg A/R S.S. rod Batch: 124816 Large Fab \*100\* Large Fab 0.00 Memo Large Fab I- Assemble and weld as per Dwg D3265 using DT9444 2- Deburr and remove all markings from material as required 3- weld mesh as per dwg 110 QC9- Inspect visual per QSI004- Fusion Welds 0.00

0.00

Memo

130

\*130\*

Powder Coating

White Gloss(Ref:4.3.5.1) per QSI005 4.3-Alum

0.00

0.00

**1ST COAT:** 

START TIME:

OVEN TEMPERATUR

FINISH TIME:

2ND COAT:

OVEN TEMPERATURE

FINISH TIME:

Powdercoat

START TIME:

DQA: Q	for	✓ Date:	13/08	7	WORK ORDER NON	-C(	ONFO			ork Order u		DART AEROSPACE
Work Order: Part No. NCR No.	P32	65-	- '		Rework Scrap Use-as-is Suspected Unapproved			Skid-tube Crosstul Machining Small Fa noforming Finishii Large Fab Composi	be ab	4	Water Jet d. Eng. Coor. re/Packaging Supplier	Engineering Quality Other
Root Cause	Date	Step	Qty	Desci	ription of work order update or non-conformance	1	nitial iief Eng	Action Description		Sign & Date	Verification	QC Inspector
Design Doc/Data Equip/Tooling Handling/Pre Material Operator Offset/Setup Process Supplier Training Transport Unapproved	3/6//22	100	*(	that that through	by Plc locks like have a oil warmer.  was not cleans own before Powercas  Basket want cleans  ush. Before weldy.	as:	16 9-8 7.042 18/1/22	Steip Aleas when.  P/c is unaccatably.  Clean thoughty  Re Power contrason.  O>Zoos  Start 7:50 Fin 8.  temp 460 > temp	:20	RE 3.7.24	13k1/25	Q57.042 13/07/22
Landing						FA	ULT CA	regory		***** ***		
Landing	Bending Centre Not Concentric Cracks Broken/Da Crimp/Kink/Ripple/Wave Cuffs Crushing Heat Treat Inspection Strip in Tube Marks/Chatter Turning Sequence Bom/Rout Bom/Rout Broken/Da Bom/Rout Broken/Da Bom/Rout Broken/Da Bom/Rout Broken/Da Bom/Rout Broken/Da Bom/Rout Broken/Da Burrs Contaminat Countersin Cut Too Sho				BOM/Route Broken/Damage/Defect Burrs Contamination Countersink Cut Too Short Drawing Drill Holes		Grain Hardwa Inspect Instruct Misalia Mislaba Misread Off-set	ion Incomplete/Unqualified tions Incomplete/Unclear gned/off center eled		Outside Dim Over/Under Part Incorred Part Lost/Mi Part Moved Positioned V Power Loss/	tolerance ct issing	Pressure/Forced Set-up Temperature/Cure Weld Wrong Stock Pulled Other
	Wave/Tw	•	e s		Fit/Function	$\vdash$	1	Sequence				

\*103137\*

Page 3

June-14-13 10:56:42 AM D3265-041 Item ID: Accept \*N900040100\* Setup Start **Revision ID:** Basket Base Assembly Item Name: \*1\* **Start Date:** 6/14/13 Start Qty: 1.00 **Cust Item ID:** Required Date: 6/28/13 Req'd Qty: 1.00 **Customer:** Reference: Run Start **Tooling: Approvals:** Process Plan: Date: Date: Stop QC: SPC (Y/N): Date: Date: Sequence ID/ Operation Set Up/ Tool ID Tool # Plan Accept Reject Reject Insp. Work Center ID Qty Number Description Code Qty Stamp **Run Hours** QC3- Inspect Part Finish 0.00 140 \*140\* 0.00 QC Memo Quality Control 0.00 150 Small Fab \*150\* Small Fab 0.00 Memo Seal support gusset seam with White Sikaflex-291 Batch: 11 (26) Small Fab Expiry date: 13/1 OC5- Inspect part completeness to step on W/O 0.00 160 \*160\* 0.00 Memo Quality Control

DQA:			Date:											
QA Closed:			Date:			WORK ORDER NON-	-C(	ONFO	RMANCE / UPDATE		ork Ordor			AEROSPACE
QA Closed.			Date.			<u> </u>		Ē	<u> </u>	VV	ork Order up	odate only	_	
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	_					Rework			Skid-tube Crosstube		]	Water Jet	٦	Engineering
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		Crimp/Kink/Ripple/Wave			<b>├</b>	Burrs		1	ion Incomplete/Unqualified	$\vdash$	Part Lost/Mi	ssing		Weld
	-	Cuffs				Contamination		1	tions Incomplete/Unclear		Part Moved			Wrong Stock Pulled
	Crushing				-	Countersink			ned/off center	L	Positioned W	Vrong _	_	
	Heat Treat			<b>-</b> 1		Cut Too Short		Mislabe			Power Loss/	Surge		Other
	Inspection Strip in Tube			Tube	<u> </u>	Drawing		Misread						
	Marks/Chatter				<u> </u>	Drill Holes		Off-set						
	Turning Sequence					Finish	Щ		Calibration					
	Wave/Twist in Tube					Fit/Function		Out of S	Sequence					

Work Ord June-14-13 10:		3137		*103	137*						Page 4
Item ID: Revision ID: Item Name:	D3265-041  Basket Base A	Assembly		Accept	*N900	040100	)* S	Setup	Start Stop	*NS	
Start Date: 6/14/13 Start Qty: 1.00 Required Date: 6/28/13 Req'd Qty: 1.00 Reference:		*1* *1*		Cust Item II Customer:	D:					•	
Reference: Approvals: Process Plan: QC:		an:	Date:	Tooling: SPC (Y/N):		ite:	I	Run	Start Stop	*NR *NR	
Sequence ID/ Work Center 1 170 *170* Packaging Packaging	ID	Operation Description Identify as per dwg & Sto Memo	ck Location: NU (O	Set Up/ Run Hours 0.00 D3 \$0	Tool ID ひ-6のそしの4	Tool # Plan Code	Accept Qty	Reje Qty	. ]	9	asp. Samp
180		QC21- Final Inspection -	Work Order Release	0.00							

0.00

Memo

\*120\*

Quality Control

ML 5 13-07-25 MF 7 35

DQA:			Date:	-·- <u>-</u>												
			5.			WORK ORDER NON-	-CC	ONFO	RMANCE / UPDATE				AEROSPACE			
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	_		Concen	itric		BOM/Route		Grain			Over/Under	<u> </u>	Set-up			
	Crac	cks				Broken/Damage/Defect		Hardwa	re	-	Part Incorred	<b> </b>	Temperature/Cure			
	Cracks Crimp/Kink/Ripple/Wave			/Wave		Burrs		Inspect	on Incomplete/Unqualified		Part Lost/Mi	<del>-</del>	Weld			
	Cuffs Cuffs					Contamination		-	ions Incomplete/Unclear		Part Moved		Wrong Stock Pulled			
	Crushing					Countersink			ned/off center		Positioned W	∟ Vrong				
	Heat Treat					Cut Too Short		Mislabe	•		Power Loss/		Other			
	Inspection Strip in Tube			Tube		Drawing		Misread	i		. ·	~ <u>L</u>				
	Marks/Chatter					Drill Holes		Off-set								
	Turning Sequence					Finish		Out of 0	Calibration							
	Turning Sequence Wave/Twist in Tube					Fit/Function		Out of 9	Sequence							

June-14-13 10:56:41 AM

Work Order ID:

103137

Parent Item:

D3265-041

Parent Item Name:

Basket Base Assembly

**Start Date:** 6/14/13

Required Date: 6/28/13

Start Qty: 1.00

Required Qty: 1.00

Comments:

IPP Rev:C Re-Format

05-11-03 JLM

IPP Rev:D 08-09-10 revC as per dwg (ecn 08-524) DD verf: by:EC IPP RevE: as per DEO DD

10.09.12 verified by:EC

IPP RevF: revise seq 110 DD 10.01.28 verified by:EC

IPP

REV:G 12.07.26 AS PER DWG REV.D DD VERF:EC

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
D2232-3	!	Manufactured	No			100	Each	29.0000	2	2	CC /	2 7	//
Basket Hinge			<b>-</b> -								u /:	5-7-1	0
				Location		Loc Qty	<u>L</u>	oc Code					
	1			WA		3							
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				755		2				_			
	i			980		4				$\left( \frac{1}{2} \right)$			
				984	13)	20	ъ.	16,0000		$\mathbb{Z}_{X}$	<i>p a</i>		
D2235-1 Basket Rib		Manufactured	No			100	Each	16.0000	1	1	CCI	13-5	7-16
Dasket Kit	1			Location		Loc Qty	<u>L</u>	oc Code	400 TA 100 T			<del></del>	
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QA Closed.			Date.				- 1			V\	ork Order u	odate only	┸	
Work Orde	er:					DISPOSITION				AGAINST D	EPARTMENT,	/PROCESS		
	-		:			Rework			Skid-tube	Crosstube	7	Water Jet	:	Engineering
Part N	۷o. ِ					Scrap			Machining	Small Fab	Pro	d. Eng. Coor.	,	Quality
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	_	Bending			L	Bend		Folio/F	rogram		Outside Dim	ensions		Pressure/Forced
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	-	Crimp/Kir	nk/Ripple,	/Wave	<del></del>	Burrs		1	ion Incomplete/Un	· -	Part Lost/Mi	ssing	L	Weld
	-	Cuffs			<b>—</b>	Contamination		1	ions Incomplete/U	nclear	Part Moved			Wrong Stock Pulled
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	Inspection Strip in Tube			Tube	<u> </u>	Drawing	_	Misread						
	-	Marks/Chatter			-	Drill Holes		Off-set						
	Turning Sequence				-	Finish		†	Calibration					
	Wave/Twist in Tube					Fit/Function	l	Out of S	Sequence					

June-14-13 10:56:41 AM

Work Order ID:	103137				
Parent Item:	D3265-041		•	<b>Start Date:</b> 6/14/13	Required Date: 6/28/13
Parent Item Name:	Basket Base Assembly			Start Qty: 1.00	Required Qty: 1.00
D2581  Mounting Bracket	Manufactured	No .	100 Each	36.0000 <b>2</b>	CC 13-7-16
		<u>Location</u> WA004 101383	<u>Loc Otv</u> 36 <b>/)さんの</b> 18	oc Code	
		70766 81253 82506	2 1 2		
		83230 85452 87706	3 2 2		
D3265-043 Rib Assembly	Manufactured	99837 No	6 100 Each	2.0000 1	1 ( 13-7-16
		<u>Location</u> WA004 90134	<u>Loc Qty</u> <u>Loc</u> 2 2	oc Code	
<b>D3265-1</b> Rib	Manufactured	No	100 Each	10.0000 1	CC 13-7-16
,		UA005 WA006 WA006 51483 55842	Loc Oty Loc Oty 2 2 8 4 4 4	oc Code	
D3265-5	Manufactured	No	100 Each	8.0000 2 oc Code	2 CC 13-7-16
		Location WA 96886	Loc Oty Loc S 8 8	Zx	

DQA:			Date:											7
						WORK ORDER NON	-CC	ONFO	RMANCE / U			_	AEROSPAC	U E
QA Closed:			Date:							<u> </u>	ork Order up	odate only		
Work Orde	er:					DISPOSITION				AGAINST D	EPARTMENT,	/PROCESS		
	-					Rework	1		Skid-tube	Crosstube	1	Water Jet	Engineering	1
Part N	٧o.					Scrap	1		Machining	Small Fab	Pro	d. Eng. Coor.	Quality	
	_					Use-as-is			noforming	Finishing		re/Packaging	Other	
NCR 1	۷o					Suspected Unapproved			Large Fab	Composite		Supplier		
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Cause	$\dashv$	Date	Step	Qty		or non-conformance	Ch	ief Eng	Descr	ription	Date	Verification	QC Inspector	
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		Cracks				Broken/Damage/Defect	Г	Hardwa	ire		Part Incorred	et 📙	Temperature/Cure	
~		Crimp/Kin	k/Ripple	/Wave		Burrs		Inspect	ion Incomplete/Ur	nqualified	Part Lost/Mi	ssing	Weld	
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	Heat Treat			•		Cut Too Short		Mislabe	eled		Power Loss/	Surge	Other	
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	Wave/Twist in Tube					Fit/Function		Out of S	Sequence					,

June-14-13 10:56:42 AM

Work Order ID: 103137 D3265-041 **Start Date:** 6/14/13 Required Date: 6/28/13 Parent Item: Start Qty: 1.00 Required Qty: 1.00 Parent Item Name: Basket Base Assembly 12.0000 D3442-5 No 100 Each Manufactured CC 13-7-16 Shim Location Loc Qty WA 98414 WA004 33282 86836 100 10.0000 D3825-041 No Each CC 13-7-16 Manufactured Rib Assembly (Basket End) Location Loc Qty Loc Code WA004 10 10 100 Each 6.0000 D3826-041 No Manufactured Rib / Gusset Assembly Loc Qty Loc Code Location WA004 100349 6 D3832-11 No 100 Each 1.0000 Manufactured Mesh (Base) Loc Qty Loc Code Location WA004 90140

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DQA:			Date:									,			
						WORK ORDER NON-	-CC	ONFO	RMANCE / UF				_		AEROSPACE
QA Closed:			Date:								W	ork Order up	date only		
Work Orde	٦r٠					DISPOSITION				AGAINST	DE	PARTMENT,	/PROCESS		
TOTAL OTAL						Rework			Skid-tube	Crosstube		1	Water Jet		Engineering
Part N	No.					Scrap			Machining	Small Fab		Pro	d. Eng. Coor.	$\dashv$	Quality
	-	-	, ,			Use-as-is			noforming	Finishing			re/Packaging	$\exists$	Other
NCR I	No.					Suspected Unapproved			Large Fab	Composite			Supplier	$\Box$	
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•		Bending				Bend		Folio/P	rogram	1		Outside Dim	ensions		Pressure/Forced
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	П	Cracks				Broken/Damage/Defect		Hardwa	re			Part Incorred	}	$\Box$	Temperature/Cure
	П	Crimp/Kir	nk/Ripple	/Wave		Burrs		Inspecti	on Incomplete/Un	qualified		Part Lost/Mi	ssing	$\sqcap$	Weld
		Crimp/Kink/Ripple/Wave Cuffs				Contamination		1	ions Incomplete/U			Part Moved	-	$\neg$	Wrong Stock Pulled
		Crushing				Countersink		-†	ned/off center			Positioned V	۷rong		
		Heat Treat				Cut Too Short		Mislabe	eled			Power Loss/	Surge		Other
		Inspection Strip in Tube				Drawing		Misread	1	•					
		Marks/Chatter				Drill Holes		Off-set							
		Turning Sequence				Finish		Out of 0	Calibration						
		Wave/Tw	ist in Tub	oe		Fit/Function	L	Out of 9	Sequence						

H:/FORMS/Quality Assurance\approved QA/NCRWO RevH

June-14-13 10:56:42 AM

Work Order ID:

103137

Parent Item:

Parent Item Name:

Basket Base Assembly

D3833-1

Mesh (Base End Face)

D3265-041

No Manufactured

100

Each

22.0000

**Start Date:** 6/14/13

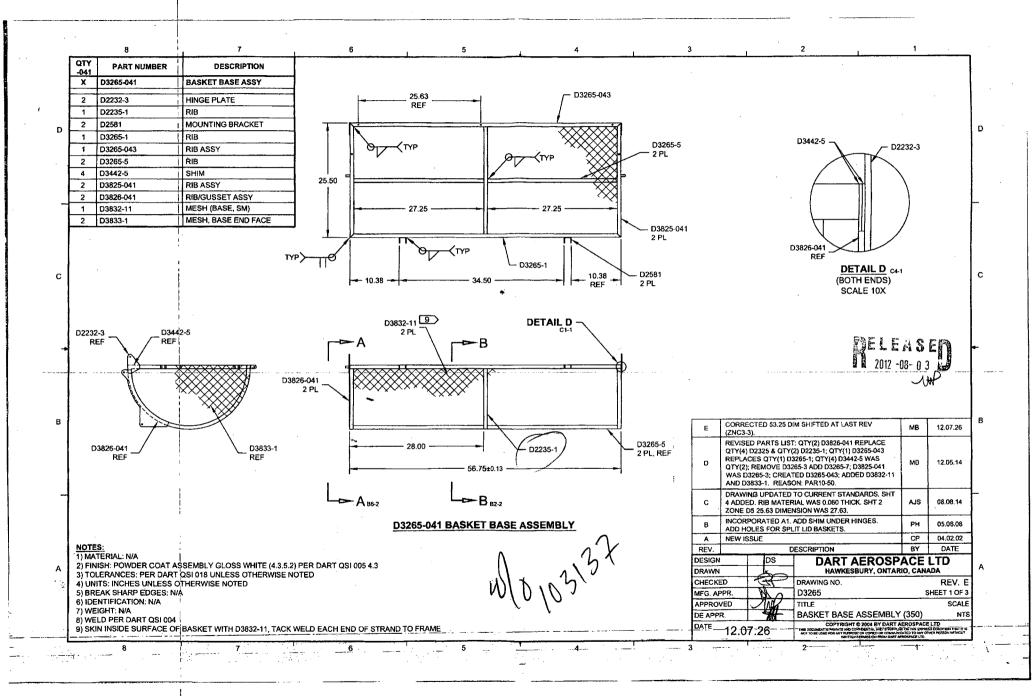
Start Qty: 1.00

Required Date: 6/28/13

Required Qty: 1.00

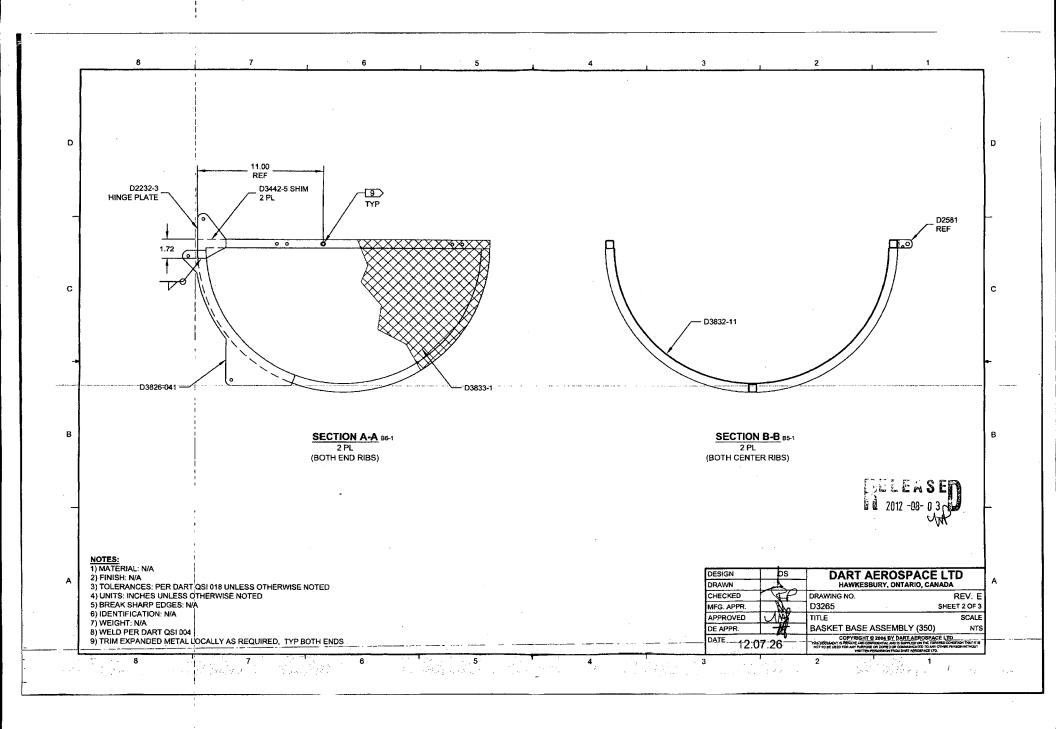
Location	Loc Qty	Loc Code	<b>398538</b>
WA	15		
98359	3		·
99268	12		
WA007	7		
77521	4		
81259	1		
89208	1		
98538	1		

DQA:			Date:						•				TO AC
QA Closed:			Date:			WORK ORDER NON	-CO	ONFO	RMANCE / UPDATE		ork Ordor un	ndata anlu	AEROSPACE
QA Closed.			Date.							VV	ork Order up	date only	
Work Orde	er:					DISPOSITION			AGAINST	ΓDE	PARTMENT	/PROCESS	į
					<del></del>	Rework	]		Skid-tube Crosstube	•	]	Water Jet	Engineering
Part N	No					Scrap	1		Machining Small Fat		Pro	d. Eng. Coor.	Quality
						Use-as-is		Therr	noforming Finishing	3	Rec/Sto	e/Packaging	Other
NCR I	No. <u>.                                   </u>				_	Suspected Unapproved	]		Large Fab Composite		]	Supplier	
	γ												
Root		İ			Desci	ription of work order update		Initial	Action		Sign &		
Cause	D	ate	Step	Qty		or non-conformance	Ch	nief Eng	Description		Date	Verification	QC Inspector
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Landii	ng Gear					General	TA.	OLI CA	ILGONI				
	Ben					Bend		l <sub>Eolio</sub> /E	Program		Outside Dim	ensions	Pressure/Forced
			t Concen	ntric		BOM/Route		Grain	10gram	-	Over/Under	<u> </u>	Set-up
	_					Broken/Damage/Defect	<b> </b>	Hardwa	*		Part Incorred	<del> </del>	Temperature/Cure
	Cracks Crimp/Kink/Ripple/Wave					Burrs		1	ion Incomplete/Unqualified		Part Lost/Mi	· <del> </del>	Weld
	Cuffs Cuffs				1	Contamination		1	tions Incomplete/Unclear	$\vdash$	Part Moved	· ·	Wrong Stock Pulled
	Crushing					Countersink		1	gned/off center		Positioned V		1
	Heat Treat					Cut Too Short		Mislabe	·		Power Loss/		Other
	Inspection Strip in Tube			Tube		Drawing		Misread			1	~ <u>L</u>	
	Marks/Chatter					Drill Holes		Off-set					
	Turning Sequence					Finish		Out of	Calibration				
	Turning Sequence Wave/Twist in Tube					Fit/Function		Out of	Seguence				

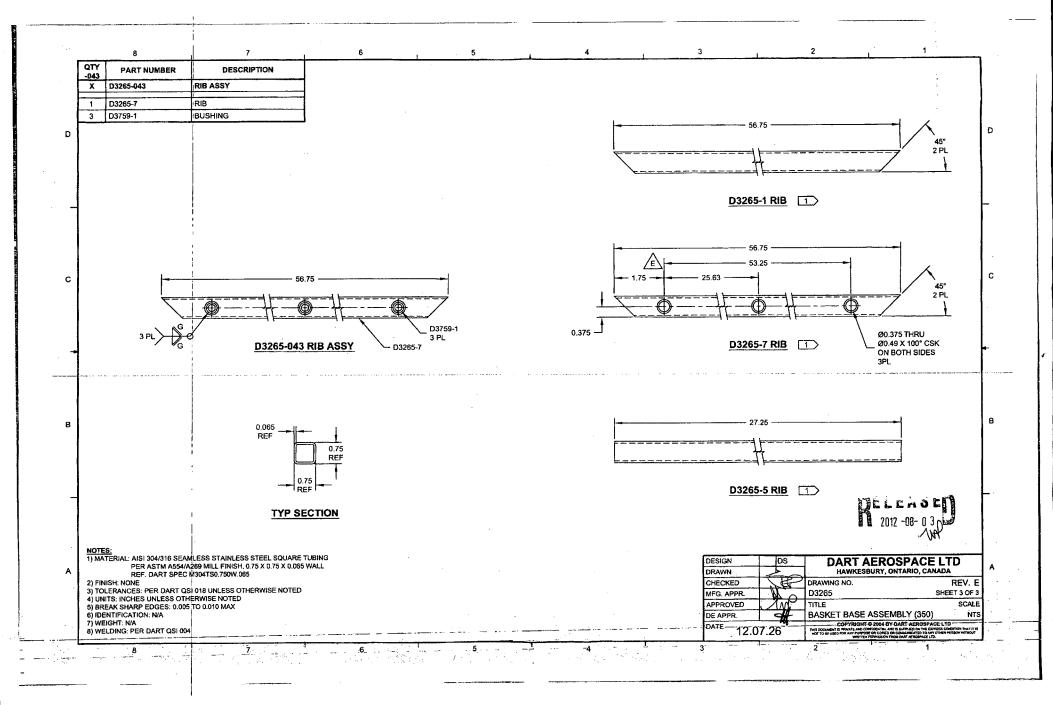


W.

DQA:			Date:													
						WORK ORDER NON-	-CC	ONFO	RMANCE / U	PDATE			AEROS PACE			
QA Closed:			Date:							V	Vork Order u	odate only				
Work Orde	er:					DISPOSITION				AGAINST D	EPARTMENT	/PROCESS				
	_					Rework			Skid-tube	Crosstube	7	Water Jet	Engineering			
Part I	Vo.					Scrap			Machining	Small Fab	Pro	d. Eng. Coor.	Quality			
						Use-as-is		Therr	moforming	Finishing		re/Packaging	Other	ĺ		
NCR I	No					Suspected Unapproved			Large Fab	Composite	]	Supplier				
Root				· · · · · · ·	Desci	ription of work order update		Initial	Act	tion	Sign &					
Cause		Date	Step	Qty		or non-conformance		ief Eng		ription	Date	Verification	QC Inspector			
Design														-		
Doc/Data											ļ					
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Landi	$\overline{}$				<b></b>	General		1		<i>,</i>		<b>_</b>	<del></del>			
	$\vdash$	Bending				Bend		1	Program		Outside Dim	ensions	Pressure/Forced			
	$\vdash$	entre No	t Concer	ntric	_	BOM/Route		Grain		· L	Over/Under	ļ	Set-up			
	$\mathbf{H}$	cracks				Broken/Damage/Defect		Hardwa		L	Part Incorred	ct _	Temperature/Cure			
	_	Crimp/Kink/Ripple/Wave				Burrs		1	ion Incomplete/Ur	_	Part Lost/Mi	ssing	Weld			
	$\vdash$	Cuffs			<u> </u>	Contamination		1	ions Incomplete/U	Jnclear	Part Moved		Wrong Stock Pulled			
	Crushing				<u> </u>	Countersink		1	gned/off center		Positioned V	_				
	Heat Treat					Cut Too Short		Mislabe		L	Power Loss/	Surge	Other			
	Inspection Strip in Tube			Tube		Drawing		Misrea								
	$\vdash$	Marks/Chatter				Drill Holes		Off-set						_		
	Turning Sequence					Finish		i	Calibration					_		
	Wave/Twist in Tube					Fit/Function		Out of	Sequence							



DQA: Date:														
•				WORK ORDER NON-CONFORMANCE / UPDATE									AEROSPACE	
QA Closed: Date:							<del></del>			Wo	rk Order up	odate only		
Work Orde	er:				DISPOSITION AGAINST			AGAINST	DEF	PARTMENT				
				-	Rework	1		Skid-tube	Crosstube	$\Box$		Water Jet		Engineering
Part N	۱o.				Scrap	1		Machining	<u> </u>			d. Eng. Coor.	$\dashv$	Quality
				_	Use-as-is	1		noforming	Finishing	⊢			┪	Other
NCR N	No				Suspected Unapproved		Large Fab Comp				Supplier			
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Root				Descr	cription of work order update		Initial	Action		-	Sign &	-		
Cause	Dat	e Step	Qty		or non-conformance	Ch	nief Eng	Descrip	Description		Date	Verification	4	QC Inspector
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	Bendi	ng			Bend		Folio/F	rogram	[		Outside Dim	ensions	T <sub>F</sub>	Pressure/Forced
	Centre Not Concentric				BOM/Route		Grain				Over/Under	tolerance		Set-up
	Cracks				Broken/Damage/Defect		Hardware				Part Incorrect			「emperature/Cure
	Crimp	/Kink/Ripple	e/Wave		Burrs		Inspection Incomplete/Unqualified				Part Lost/Mi	ssing	$\neg$	Weld
	Cuffs				Contamination		Instructions Incomplete/Unclear				Part Moved			Wrong Stock Pulled
	Crushing				Countersink		Misaligned/off center				Positioned W	Vrong _	_	
	Heat	reat			Cut Too Short		Mislabeled				Power Loss/	Surge [	<u></u>	Other
ļ	Inspection Strip in Tube				Drawing		Misread			_				
l	Marks	/Chatter			Drill Holes	$ldsymbol{f eta}$	Off-set							
		ng Sequence			Finish		4	Calibration		_				
	l lWave	/Twist in Tul	he	- 1	Fit/Function	1	Out of	Sequence						



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DQA: Date: _														TOAC
					WORK ORDER NON-CONFORMANCE / UPDATE									
QA Closed: Date:						Work Order update only								
Work Order:					DISPOSITION									
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Part No.						Scrap	1		Skid-tube Crosstube  Machining Small Fab		<b>├</b> ──			Quality
					_	Use-as-is	Thermoforming Finishing				•	re/Packaging	Other	
NCR No.						Suspected Unapproved	1 1	İ	Large Fab Composite				Supplier	
Root					Desc	ription of work order update	1	nitial	Ac	tion		Sign &		
Cause		Date	Step	Qty		or non-conformance	Ch	ief Eng	g Description			Date	Verification	QC Inspector
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		Bending				Bend		Folio/P	rogram	ram		Outside Dim	ensions	Pressure/Forced
		Centre Not Concentric				BOM/Route		Grain				Over/Under	tolerance	Set-up
		Cracks				Broken/Damage/Defect		Hardwa	ire			Part Incorrect		Temperature/Cure
,		Crimp/Kir	nk/Ripple	/Wave		Burrs		Inspect	ion Incomplete/U	Inqualified		Part Lost/Mi	ssing	Weld
					Contamination		Instructions Incomplete/Unclear			L	Part Moved		Wrong Stock Pulled	
,	Crushing				Countersink		Misalig	lisaligned/off center			Positioned V	Vrong	<b>-</b>	
	-	Heat Treat				Cut Too Short	$\vdash$	Mislabe			L	Power Loss/	Surge	Other
	_	Inspection Strip in Tube Drawing				$\vdash$	Misread			<u></u>				
	Marks/Chatter				$\vdash$	Drill Holes	<u>_</u>	Off-set						
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Wave/Twist in Tube					1	Fit/Function	1	IOut of 9	Seguence					Ï